

Date: Friday, 22/09/2006 10:48:07 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 24267E	
<b>Estimate Number</b> : 10283	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D31991
<b>This Issue</b> : 22/09/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3199 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : <i>N/A</i>
<b>First Issue</b> : 11/11/2005 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 24266E	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 30/11/2005
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	<b>Qty:</b> <i>28</i> <b>Um:</b> Each
<b>Comment</b> : Est Rev:C Removed Scribing 05-11-05 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 0.0990 sf(s)/Unit Total: 2.6730 sf(s)  
 304/316 .040 Sheet

*M 10/12/64 M 08 09 22*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

*M 08 09 22*

*(28)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*M 08 09 22*

*(28)*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*08 09 26 Counted (28)*

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form as per Dwg D3199

*SB 06/10/12 28*

2-Deburr if necessary

*MF 06/09/26 (28)*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 24267E

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Job 10.12 (28)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*a.m 06/10/10 (28)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06/10/23 (28)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5138*

*06/10/23 (28)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DP 06/10/23 (28)*

Job Completion



*CLog 10/10/23*

ASAP

Date: Tuesday, 19/09/2006 10:17:47 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 24267E	
<b>Estimate Number</b> : 10283	
<b>P.O. Number</b> :	<b>Part Number</b> : D31991
<b>This Issue</b> : 19/09/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3199 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : 11/11/2005 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 24266E	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/11/2005 <b>Qty:</b> 27 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:C Removed Scribing 05-11-05 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

Email or Ship DXF file to vendor Laser Cut D3199-1 bracket per Dwg D3199

Material release note is required

*W. J. Ferret*  
*11 06 09 22* (27)

2.0	D31991	Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 27.0000 Each(s)

Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form as per Dwg D3199

2-Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/09/2006 10:17:47 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 24267E

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

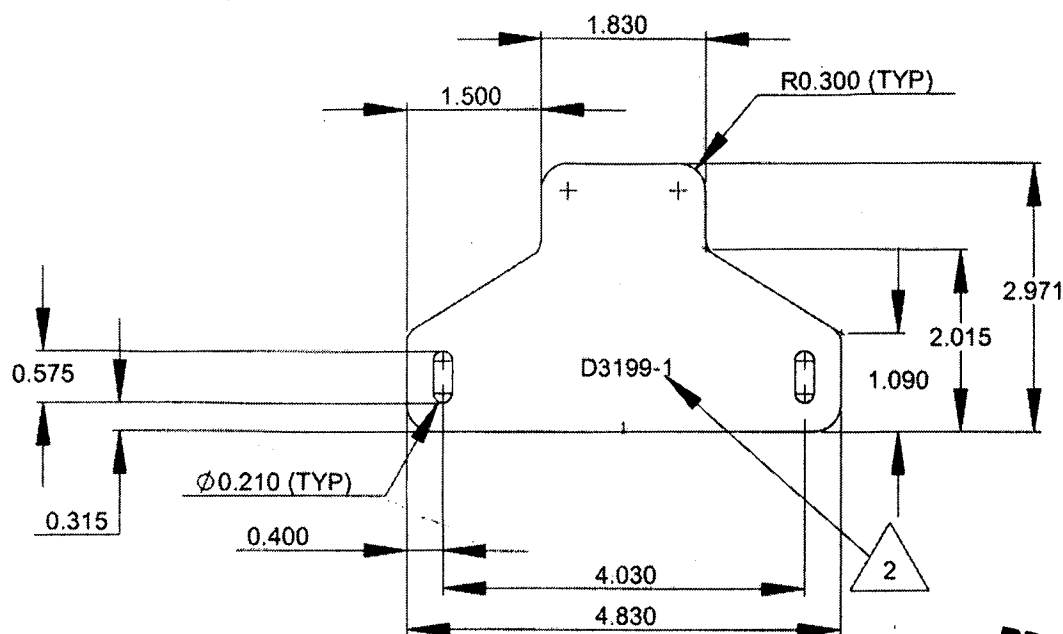
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



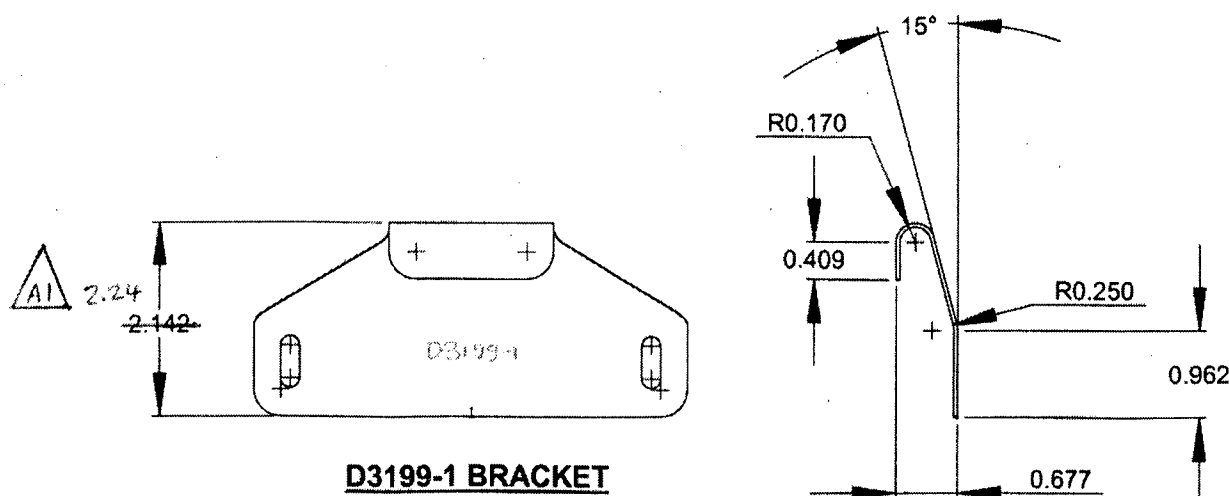
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. <b>D3199</b>	REV. A SHEET 1 OF 1
DATE <b>03.08.05</b>		TITLE <b>BRACKET</b>	SCALE 1:2
A	03.08.05	NEW ISSUE	
A1	04.03.01 <i>CP</i>	2.24 WAS 2.142	

RELEASED  
03-09-02



## D3199-1 FLAT PATTERN

**REFERENCE ONLY**



## NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED  
2) SCRIBE DART P/N D3199-1 AS SHOWN.  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.  
5) ALL DIMENSIONS ARE IN INCHES.

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